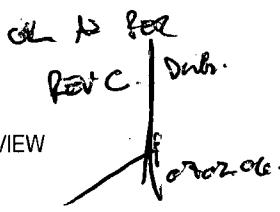


Date: Monday, 2/5/2007 4:02:32 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BAR	
Job Number	: 30654		Part Number	: D31964	
Estimate Number	: 10389		Drawing Number	: D3196 UNDER REVIEW	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/5/2007	S.O. No. : N/A	Drawing Revision	: U/R	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 2/5/2007	Type : MACHINED PARTS	Due Date	: 2/23/2007	
Previous Run	: 29965		Qty:	8	
Written By					
Checked & Approved By					
Comment	: Est Rev A New Issue 05-11-08 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"	
		Comment: Qty.: 3.0345 f(s)/Unit Total : 24.2760 f(s) Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) Identify for D3196-4 Batch: M103321	J.F. 07/02/26 (8)
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blank: (0.75" x 1.50") x 34.750" long Bar	J.F. 07/02/26 (8)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1  1-Machine D3196-4 as per Folio FA339 and Dwg D3196 Identify as D3196-4	
		2-Deburr	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 07/02/27 (8)
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.F. 07/02/27 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 03/03/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:33 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 30654

Part Number: D31964

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL

07/02/28X8

7.0 POWDER COATING

POWDER COATING



M101601

YL

07/02/28X8

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/3/02

(8)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PC 7/3/02

(8)

(8)

Comment: FINAL INSPECTION/W/O RELEASE



Q 07/03/05

Job Completion



U 07/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bar		Part Number:	D3196-4
Inspection Dwg: D3196	Rev: B 07.02.06		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	—			
33.650	+/-0.010	33.650	—			
16.639	+/-0.010	16.639	—			
0.488	+/-0.010	0.488	—			
0.962	+/-0.005	0.962	—			
0.464	+/-0.010	0.465	—			
0.504	+/-0.010	0.503	—			
Ø0.344	+0.006/-0.001	Ø0.348	—			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	Ø0.665 x 100	✓			
0.512	+/-0.005	0.510	—			
0.060 x 45°	+/-0.010 x 0.5°	0.055 x 45	—			
4.750	+/-0.010	4.750	—			
12.531	+/-0.010	12.531	—			
16.627	+/-0.010	16.627	—			
21.844	+/-0.010	21.844	—			
29.625	+/-0.010	29.625	—			
0.250	+/-0.010	0.250	—			
1.000	+/-0.010	0.999	—			
R0.125	+/-0.010	R0.125	—			
0.987	+/-0.010	0.987	—			

Measured by:	<i>JNL</i>	Audited by:	<i>SJS</i>	Prototype Approval:	N/A
Date:	07/02/27	Date:	07/02/27	Date:	N/A

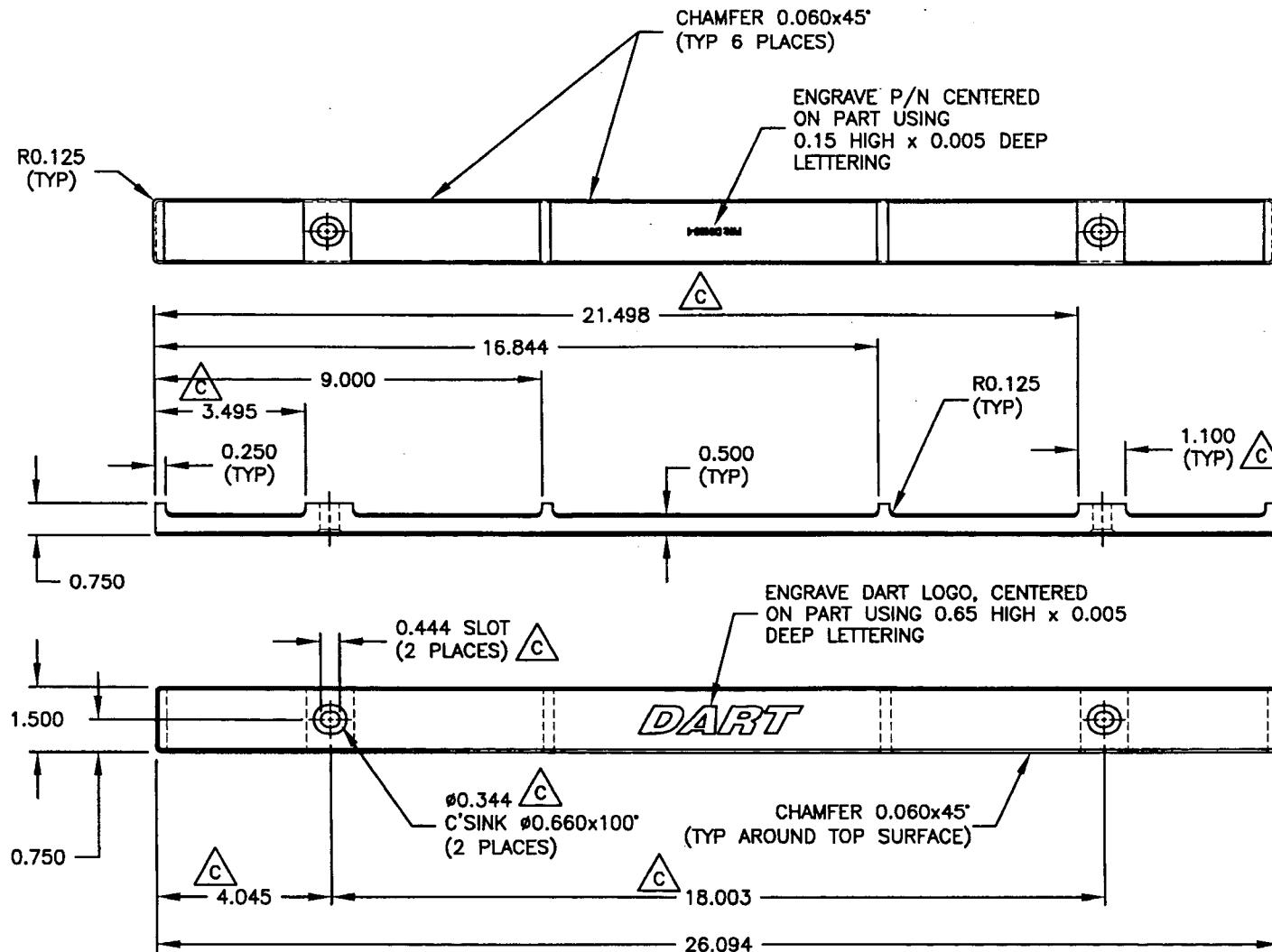
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM <i>JF</i>	<i>PZ</i>

**DART**

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
REV. C

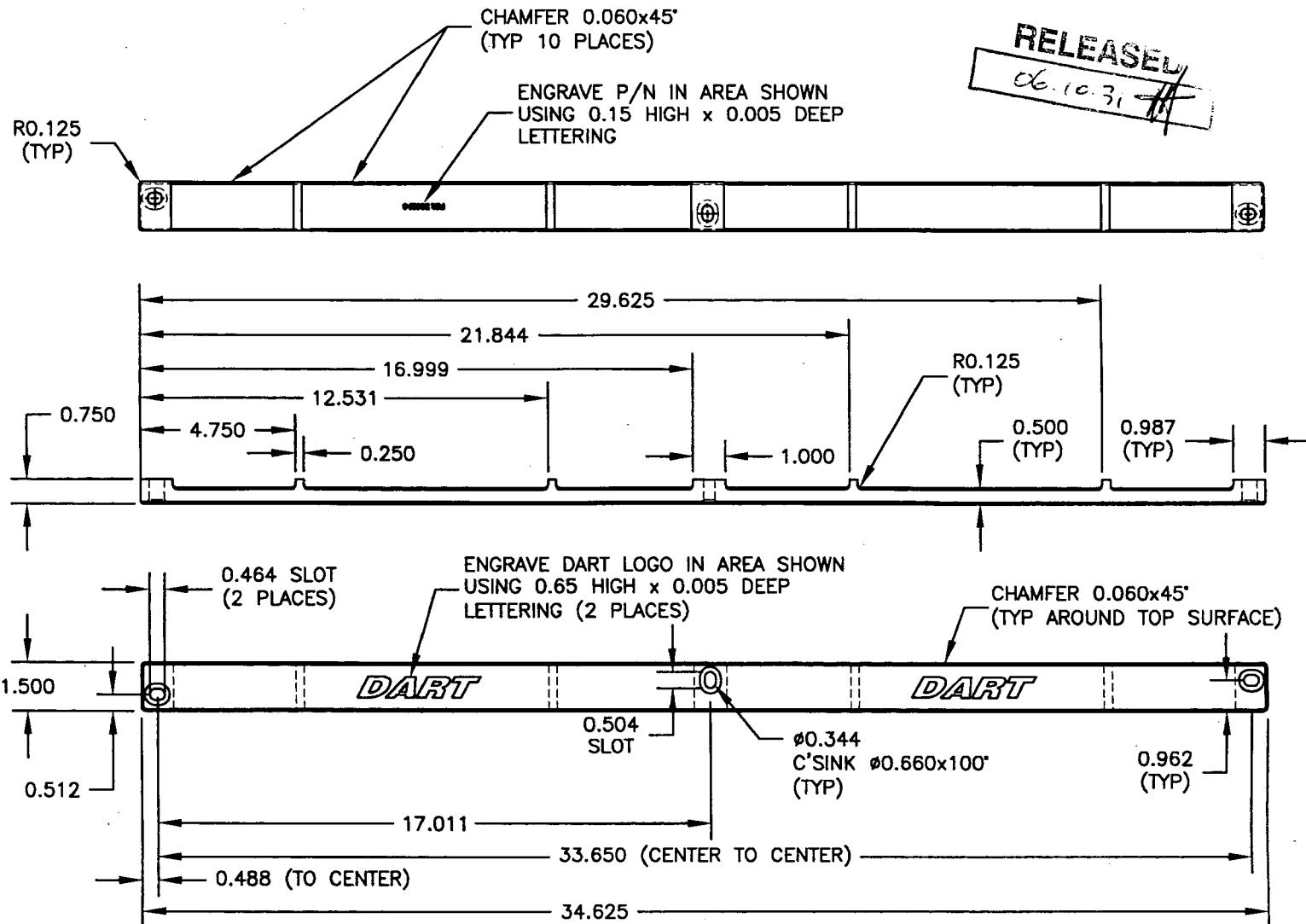
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<i>GP</i>	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>Pt</i>	<i>MH</i>	D3196
DATE		SHEET 1 OF 3
06.10.31		SCALE
A	03.06.25	1:4
B	06.09.25	
C	06.10.31	
	NEW ISSUE	
	ADD D3196-5	
	ADD SLOTS ON -1; REMOVED -5	

RELEASED  
*dc 10.31-ff*

**D3196-1 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *30654*



**D3196-3 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

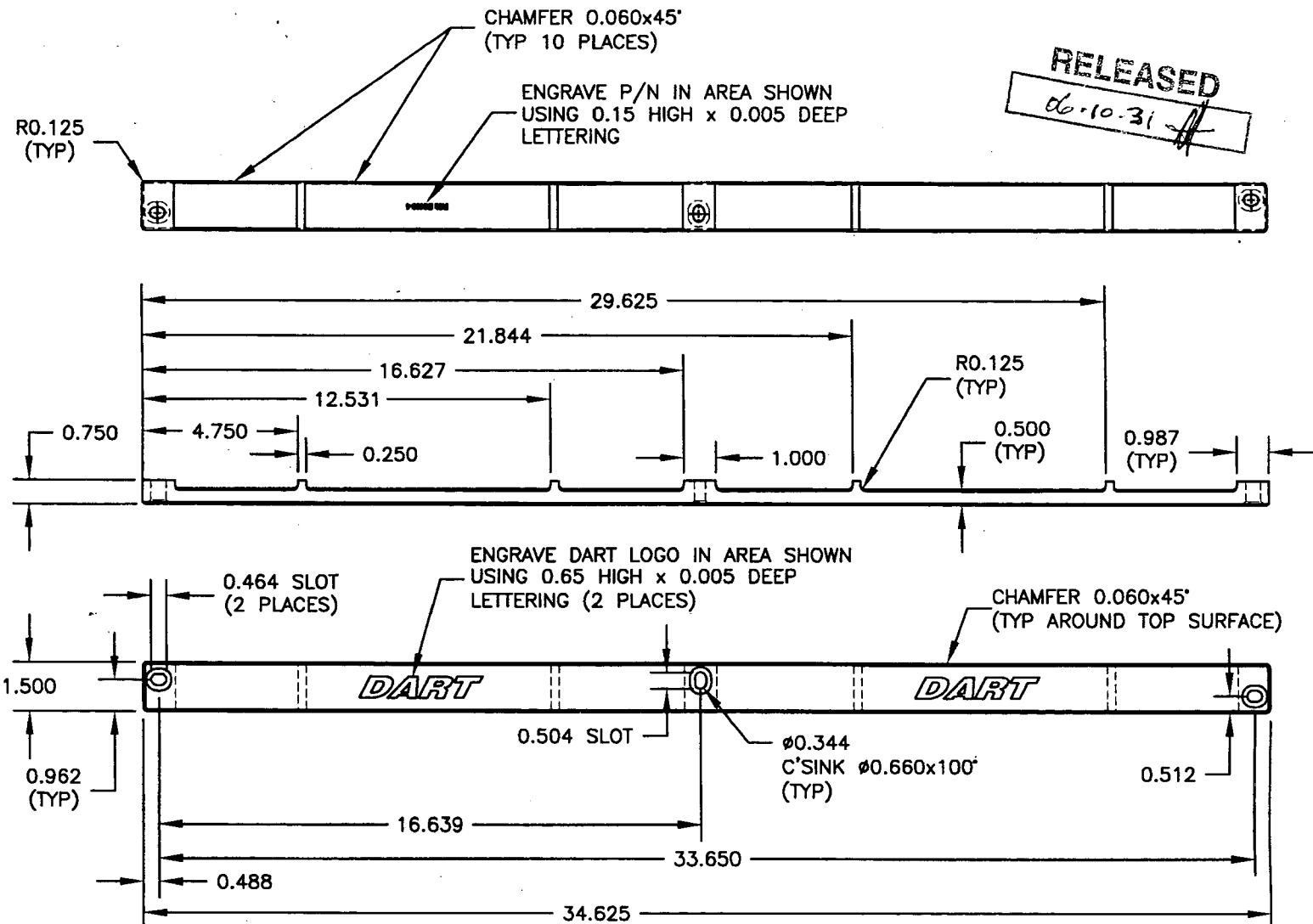
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DESIGN	DRAWN BY	DART AEROSPACE LTD
<i>Q</i>	<i>JB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>MM</i>	D3196
DATE	TITLE	SCALE
06.10.31	BAR	1:5

**DART**

**RELEASED**  
*06.10.31 MM*



### D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE  
WORK ORDER  
NO. 30654

DESIGN	Q1	DRAWN BY	JL
CHECKED	PH	APPROVED	MM
DATE	06.10.31	DRAWING NO.	D3196
		TITLE	BAR
REV. C		SHEET 3 OF 3	
SCALE	1:5		

**DART**

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA